

Work Order ID 163091

Wednesday, June 21, 2017 11:45:09 AM

163091

Page 1

Item ID: D5326-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 7/5/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

JUN 21 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5326

A

100

Weld per dwg A/R S.S. rod Batch: **4135068** 0.00***100***

Large Fab

Memo

0.00

Large Fab

1- Cut D5326-1 as per dwg
2- Drill holes as per dwg D5332 using DT10194
3- Remove identification marks and deburr
4- Weld bushing in rib as per dwg and grind flush

3x D.M.L. 2017-06-28**DAS 43 JUL 03 2017 9-89**

110

QC10- Inspect visual per QSI004- ground welds 0.00

110

QC

Memo

0.00

Quality Control

3 JUL 03 2017 9-89

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

3 JUL 03 2017 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 163091

Wednesday, June 21, 2017 11:45:09 AM

163091

Page 2

Item ID: D5326-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly
Start Date: 7/5/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/10/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
43
-39

JUL 03 2017

17/7/4

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, June 21, 2017 11:45:09 AM

Page 1

Work Order ID: 163091

163091

Parent Item: D5326-041

D5326-041

Parent Item Name: Rib Assembly

Start Date: 7/5/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5338-1		Manufactured	No			100	Each	47.0000	2	2			
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D5338-1

Bushing

**B 159843 → 6x DAS 43 JUL 03 2017 9-89

Location	Loc Qty	Loc Code
----------	---------	----------

WA004	47	
159303	17	
159843	30	

M304TS0.500W.049

Purchased

No

100 f

359.7068

1.9

2

M304TS0 500W 049

Square Tubing

**

D.M.L 2017-06-28

Location	Loc Qty	Loc Code
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WA004	359.70684	
M135215	31.06	
M136011	21.64684	
M137257	307	

8

DQA: _____ Date: _____



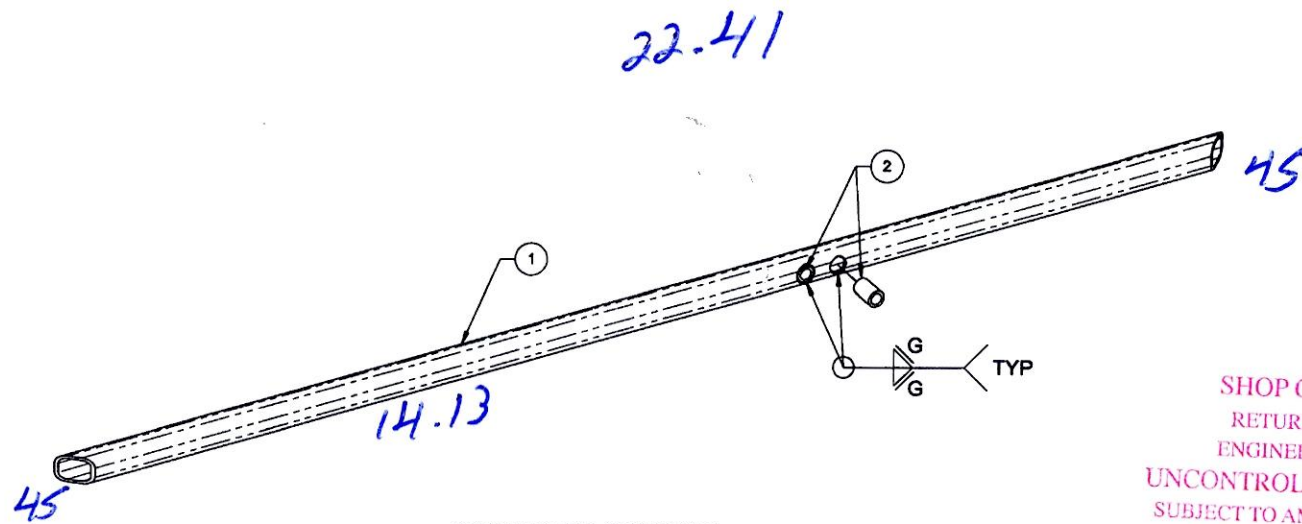
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5326-041	RIB ASSEMBLY
1	1	D5326-1	RIB
2	2	D5338-1	BUSHING



D5326-041 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163091A
JUN 21 2017

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
7) WEIGHT: 0.49 lbs
8) WELD PER QSI 004

Bit. 297

RELEASED
2016-01-21
EEN 16-506

APPROVED

A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5326	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	RIB ASSEMBLY	NTS
DATE	15.08.10	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	